

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003392**Date Inspected:** 06-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower,Jacking and Deviation Saddle**Summary of Items Observed:**

The following report is based on METS observations at Japan Steel Works (JSW) in Muroran Japan. Current work: Casting, machining and repair of Saddles.

At 1000 hours, the Caltrans Quality Assurance (QA) inspector arrived at JSW fabrication shop number 4 and observed a welding procedure qualification test designated GJ6-3402 SW-3-2 performed by JWS welding personnel Mr. K. Kobayashi, ID 08-5023 and Mr. N. Murai. The welding was performed utilizing the Flux Core Arc Welding Process in the Flat (1F) position. The filler metal appeared to be TM-55, E-70T-5MJ H4 AWS designation A5.29, 1.6mm diameter with dual shield. The welding was performed per the AWS D1.5, 2002 Section 5.10.3 and Figure 5.8 requirements. The Intertek QC inspectors, Mr. Makhmud Ashadi checked welding parameter and recorded the preheat Temperature was over 160C and interpass Temperatures Max 260C, the average amperage of 270amps, voltage of 27volts, gas flow rate was 25 liter/min and the average travel speed was 314mm/min. The QA inspector observed that the both welders ground each weld pass to smooth bright finish prior to starting the next weld pass. The welding of these plates was not completed on this date.

Summary of Conversations:

No specific conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer, (858) 967-6363, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
